Quality Control

es / No				WORK ORDER NON-C	CONF	FORN	ANCE / UP	DATE			
					•				QA Closed:	Date	
r·	ì			DISPOSITION				AGAINST DE	PARTMENT	PROCESS .	
Work Order:				Rework	1 I		Skid-tube	Crosstube		Water Jet	Engineering
Ο.				I	1		}	—	Pro	<u> </u>	Quality
				Use-as-is	1 -				•		Other
o				Work Order Update]		Large Fab	Composite		Supplier	
	ı.	1						•••	C:== 0		<u> </u>
	<u> </u>			•	i .				_	Varification	QC Inspector
Date	Step	Qty	(or Non-conformance	Cnie	T Eng	Desc	ription	Date	vernication	QC IIIspector
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.	L	L	<u> </u>	F.	AULT	CATE	GORY		1		
g Gear											
				Bend	П	arain			Ovalized		Pressure/Forced
	ot Concei	ntric to	o/s	BOM/Route	Н	lardwa	re		Over/Under	tolerance	Temperature/Cure
Cracks				Broken/Damaged	In	nspecti	on Incomplete		Part Incorre	ct	Weld
Crushed/	Crimped.			Burrs	In	nstruct	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
Cuffs	•			Contamination	\square	/lainte	nance		Part Moved		
Heat Trea	rt	• '		Countersink	\square	∕lislabe	led		Positioned V	Vrong	_
Inspection	n Strip in	Tube		Cut Too Short	\square	Misread			Power Loss/Surge		Other
Ripples in	Bend			Drill Holes	По	Offset					
Torque W	aves in E	extrusion	n	Drawing	По	ot of C	Calibration				
Turning S	equence			Finish		ot of S	equence				
	g Gear Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in Torque W	r: O. Date Step Date Step Bending Centre Not Concer Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Ripples in Bend Torque Waves in E	r: O. Date Step Qty Bending Centre Not Concentric to Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend	r:	Disposition Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update or Non-conformance Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Burrs Cuffs Contamination Cuffs Contersink Inspection Strip in Tube Ripples in Bend Drill Holes Torque Waves in Extrusion Drawing	Table 1	PAULT CATE Gear Bending Centre Not Concentric to O/S Cracks Cracks Crushed/Crimped. Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Rework Scrap Use-as-is Work Order Update Initial Chief Eng FAULT CATE General Bend Bom/Route Bom/Ro	TELLIT CATEGORY General Bending Centre Not Concentric to O/S Cracks Cracks Broken/Damaged Crushed/Crimped. Crushed/Crimped. Cutfs Heat Treat Inspection Strip in Tube Rework Scrap Use-as-is Work Order Update Vor Non-conformance FAULT CATEGORY General Bend Bend Bend Bend Bend Bend Bend Bend	TOTALE PROBLEM TO THE	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update Date Step Qty Or Non-conformance Step Qty Or Non-conformance Centre Not Concentric to O/S BOM/Route Hardware Crushed/Crimped Burrs Distinction Sign & Down/Damaged Centre Not Concentric to O/S Cracks Broken/Damaged Instructions incomplete Part Incorrection Crushed/Crimped Burrs Instructions incomplete Part Incorrection Maintenance Part Noved Heat Treat Countersink Mislabeled Positioned Wiscond Torque Waves in Extrusion Drawing Other Counters of Counter Not Collaboration Drawing Other Counters of Count	DISPOSITION Rework O. DISPOSITION Rework Scrap Use-as-is Work Order Update Date Date Step Qty Description of work order update or Non-conformance Date Step Qty Description of work order update or Non-conformance Chief Eng Description FAULT CATEGORY Gear General Bending Centre Not Concentric to O/S Cracks Broken/Damaged Inspection Incomplete Broken/Damaged Inspection Incomplete Inspection Incomplete Instructions Incomplete/Unclear Instructions Incomplete/Unclear Instructions Incomplete/Unclear Part Lost/Missing Cuffs Contamination Maintenance Part Moved Positioned Wrong Power Loss/Surge Inspection Strip in Tube Ripples in Bend Offset Out of Calibration Drawing Out of Calibration

Outside Dimensions

Date:

DQA:____

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Identify as per dwg & Stock Location: \(\sum_{OO} \sqrt{\capa} \)

140 Packaging

140

150

Packaging

Memo

0.00

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Page 2

Insp.

NCR:	Yes	/ No		:		WORK ORDER NON-C		NFORM	MANCE / UPL	DATE	QA Closed:	Date:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part N	- No					Rework Scrap Use-as-is Work Order Update		ا Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				-	Descri	ption of work order update	ı	nitial	Act	ion	Sign &		,
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUL	T CATE	GORY	<u>- ;;</u>			
Landi	mg Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Inspect Instruc Mainte Mislabe Misrea Offset		Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other			
	1 1	Turning S	eauence		- 1	Finish	1	Out of S	Sequence				

Outside Dimensions

Date:

DQA:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

March-12-13 1:47:21 PM

Work Order ID:

98330

Parent Item:

D2366

Parent Item Name:

Lock Handle

Start Date: 3/11/13

Required Date: 3/18/13

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

PP B00.05.04ReformatEC

IPP Rev:C Now on Waterjet 07-04-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	151.2500	0.0174	0.2197896			Tm134-26
				Location		Loc Otv	Lo	oc Code					

124956

124956

NCR: `	Yes	/ No			,	WORK ORDER NON-	COI	NFORI	VIANCE / UPI	DATE	QA Closed:	Date	e:
Work Orde				Ī		DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	٠ . No.			i		Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				i	Descri	ption of work order update	T	Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data				;		1			• -				
Equip/Tooling												`	
Operator													
Material				İ	1								,
Setup	Ш		!						,				•
Other			· ·										
Process													
Supplier	Ш												
Training													
Unapproved			<u> </u>	<u> </u>	1			TCATE	CORY		1	<u> </u>	
						General	AUI	LT CATE	GURY				
Landi	_	Bending				Bend	_	Grain		- ا	Ovalized	Г	Pressure/Forced
	\vdash	Centre N	ot Conco	ntric to	0/5	BOM/Route	-	Hardwa	ıre		Over/Under	tolerance	Temperature/Cure
	\vdash	Cracks	or conce		^{0/3} -	Broken/Damaged	\vdash	4	ion Incomplete		Part Incorre	F	Weld
	-	Crushed/	Crimned		-	Burrs	-	4	ions Incomplete/	Unclear	Part Lost/M	-	Wrong Stock Pulled
	-	Cuffs	crimped		-	Contamination	\vdash	Mainte			Part Moved	-	
	ь	Heat Trea	at	1	-	Countersink		Mislabe		 	Positioned		
	-	Inspectio		Tube	<u> </u>	Cut Too Short	\vdash	Misread			Power Loss,	r	Other
	_	Ripples in			-	Drill Holes		Offset		L	-	- L	
	Н	Torque W		Extrusio	on	Drawing		4	Calibration				
	П	Turning S				H G Finish		Out of	Sequence				

Outside Dimensions

Date:

DQA:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	98330
Description: Lock Handle	Part Number:	D2366
Inspection Dwg: D2366 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	0,193"	-		V	JLm01
0.750	+/-0.010	0.753"	_		V	
0.344	+/-0.010	0,342"	_		ν	
1.196	+/-0.010	0,342"	-		٧	
2.750	+/-0.010	2.749"	_		V	·
			'			
	;					
			,			

Measured by: Jm Audited by: 27 Prototype Approval: N/A

Date: 13-4-28 Date: 13 4 39 Date: N/A

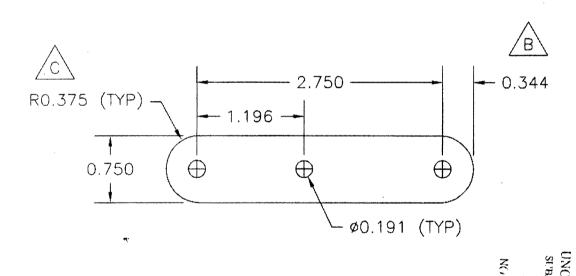
Rev	Date	Change	Revised by	Approved
Α	08.02.28	New Issue	KJ/DD	100
	-			





	DESIGN B	w	DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO, C	
	CHECKE	9	APPROVED	DRAWING NO.	REV. C
l	#	#-	- ##	D2366	SHEET 1 OF 1
	DATE		L	TITLE	SCALE
	00.04	1.24		LOCK HANDLE	1:1
	Α		95.02.20	NEW ISSUE	
	В		96.06.10	R0.50 WAS R0.354; 0.344	WAS 0.300
	С		00.04.24	R0.375 WAS R0.50	





MATERIAL: AISI 304/316 SS 0.040 THICK TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSION ARE INCHES

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